

Date: Monday, 7/9/2007 11:47:01 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
Job Number : 33360	REVIEW CB
Estimate Number : 10939	07.07.09
P.O. Number : N/A	Part Number : D29382
This Issue : 7/9/2007 S.O. No. : N/A	Drawing Number : D2938 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 32383	Material : N/A
Written By : <u>07.07.09</u>	Due Date : 7/30/2007 Qty: 20 Um: Each
Checked & Approved By : <u>07.07.09</u>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC	
Est Rev: C As per Rev C 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: B31387

J.L 07/08/18

(20)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Debur

J.L 07/08/18

(20)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.L 07/08/18

(20)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.L 07/08/18

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER

REVIEW CB 07.07.09

Job Number: 33360

Part Number: D29382

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML 07/08/20

(20)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ML

07-08-24

(20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M/05068

FL

07/08/24 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

U

07-08-24

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

U

07-08-24

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20)

07/08/27

Job Completion



U 07-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33360
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.122	.122	.123		
B	0.100	0.140		.126	.122	.122	.123		
C	0.100	0.140		.120	.119	.120	.121		
D	0.210	0.230		.219	.219	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.240	.239	.239	.239		
N	0.100	0.140		.116	.121	.122	.122		
O	0.540	0.560		.550	.549	.551	.550		
P	0.490	0.510		.499	.501	.500	.499		
Q	3.715	3.725		3.719	3.719	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.254	.251	.250	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.256	1.262	1.263	1.260		
Y	1.565	1.585		1.576	1.577	1.577	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SL
Date:	07/08/18

Audited by:	mf
Date:	07/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	mf

DART AEROSPACE LTD	Work Order: 333600
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.124	.123	.123	.123		
B	0.100	0.140		.124	.123	.123	.123		
C	0.100	0.140		.123	.122	.122	.123		
D	0.210	0.230		.221	.220	.220	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.576	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.120	.121	.122	.122		
O	0.540	0.560		.550	.551	.550	.551		
P	0.490	0.510		.499	.500	.501	.498		
Q	3.715	3.725		3.720	3.719	3.719	3.719		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.251	.251	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.366	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.260	1.260	1.259	1.260		
Y	1.565	1.585		1.574	1.574	1.571	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L.
Date: 07/08/19

Audited by: [Signature]
Date: 07/08/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

DART AEROSPACE LTD	Work Order:	333600
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.123	.123	.122	.124		
B	0.100	0.140		.123	.123	.122	.124		
C	0.100	0.140		.121	.123	.121	.121		
D	0.210	0.230		.219	.221	.220	.222		
E	1.245	1.255		1.250	1.256	1.250	1.250		
F	1.245	1.255		1.250	1.256	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.576	1.574	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.122	.123	.121	.120		
O	0.540	0.560		.551	.550	.550	.551		
P	0.490	0.510		.500	.501	.501	.502		
Q	3.715	3.725		3.720	3.719	3.719	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.252	.252	.253		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.629	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.261	1.260	1.261	1.261		
Y	1.565	1.585		1.572	1.574	1.574	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	07/08/19

Audited by:	JL
Date:	07/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	33360
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121	.121	.122	.121		
B	0.100	0.140		.121	.121	.122	.121		
C	0.100	0.140		.119	.119	.121	.120		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.576	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.499		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.238	.239	.239	.239		
N	0.100	0.140		.122	.123	.122	.122		
O	0.540	0.560		.551	.551	.551	.551		
P	0.490	0.510		.500	.501	.502	.501		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.250	.251	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.261	1.262	1.260	1.261		
Y	1.565	1.585		1.574	1.573	1.573	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	07/08/20

Audited by:	ml
Date:	07/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 33360
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

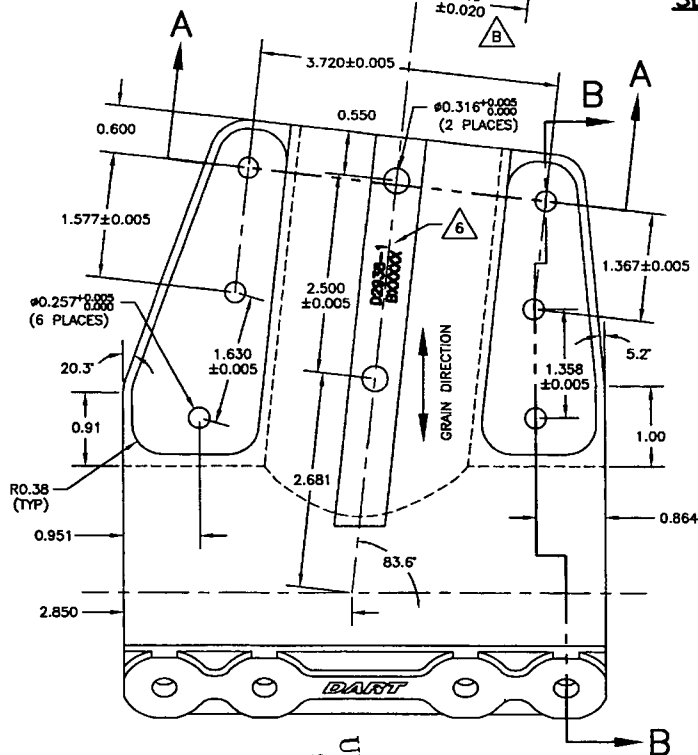
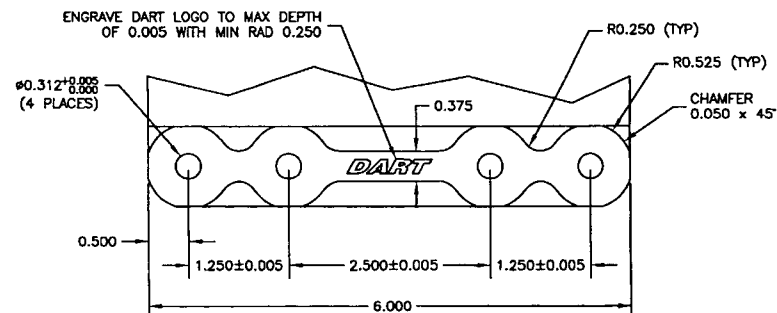
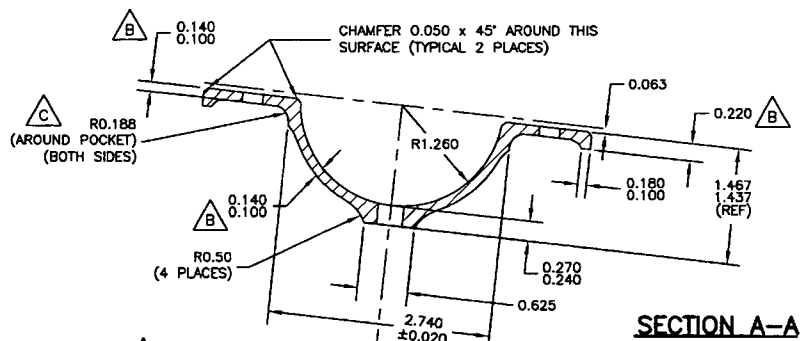
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.122	.120	.121		
B	0.100	0.140		.121	.122	.120	.121		
C	0.100	0.140		.120	.121	.119	.119		
D	0.210	0.230		.220	.222	.222	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.316	.316	.316	.316		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.121	.121	.123	.121		
O	0.540	0.560		.551	.552	.551	.551		
P	0.490	0.510		.502	.502	.502	.500		
Q	3.715	3.725		3.719	3.719	3.720	3.719		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.252	.253	.250		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.629	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.321	.321	.321	.321		
X	1.250	1.270		1.261	1.263	1.263	1.260		
Y	1.565	1.585		1.575	1.574	1.575	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

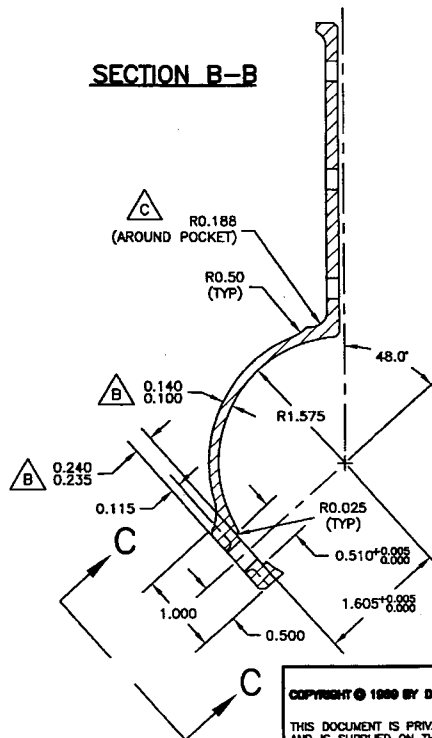
Measured by:	J.L.
Date:	07/08/20

Audited by:	me
Date:	07/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION B-B



D2938-1 LH SADDLE (SHOWN) D2938-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2938
DATE	TITLE	REV. C SHEET 1 OF 1
06.11.09	SADDLE OUTSIDE	SCALE 2:3

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NO. 133360

07.02.12